

Date: Wednesday, 1/24/2007 4:45:44 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HIGH AFT X-TUBE 412		
Job Number	: 30426		Part Number	: D412664203		
Estimate Number	: 10559		Drawing Number	: D412-664-243 REV C		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 1/24/2007 S.O. No. : N/A		Drawing Revision	: C		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 2/28/2007 Qty: 1 Um: Each		
Previous Run	: 30425					
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev:E 04.02.16 Reformat; Added D3189-1 KDS Est Rev:F 06-03-29 Remove Coments on Pick List JLM est rev G 06.12.08 per ECN 886 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL  Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D412-664-203 CHG 005
2.0	D6009129	Crosstube Material  Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D6009-129 Crosstube <u>326548</u> Check OD = 3.500"; ID = 2.250"
3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE  Comment: MORI SEIKI CNC LATHE LARGE 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166 2-Turn first side as per Folio FA166 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.
4.0	QC1	INSPECT ALL DIM TO DIM SHEET  Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 30426

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3- Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243
(engrave on outside of tube)

Inside of Cuff(Donot

7/2/02/03

6.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

7/2/02/03

7.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 07.02.05

8.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

BB 07-02-07

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD 2-2-7

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BB 07-02-07

07-02-07

11.0 QC3/5 INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

BB 07-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 30426

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

DP/EL 7-3-1

13.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

107/03/08 ①

14.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

RT 07-03-08

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

JD 7-3-9

15.0 HAND FINISHING HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-3-9

16.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-03-21

17.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

LPI

18.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 3499 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

07/03/10 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Job Number: 30426

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

(Y070402 0)

20.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

21.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

BT 07-04-16

2-Paint outside crosstube with White Imron as per QSI 005 4.2

22.0 QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

23.0 D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty	Part number	Description	Batch
2	D2856-600(Cut to 10.090")	Abrasion Strip	26650

ml 07 01 18

24.0 D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2896-1	Support	30200

BT 07 07-19

25.0 D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
2	D3189-1	Chafing Sheild	32513

ml 07 07 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30426

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 MS2192028 Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch
4 MS21920-28 Clamp 103896

MIL 070718

27.0 MS2192032 clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)
batch: 102931

BT 07-07-19

28.0 D2732 Rubber Extrusion



Comment: Qty.: 1.0290 f(s)/Unit Total : 1.0290 f(s)

Rubber Extrusion

Cut qty 2 5.80" long

qty part # description batch
2 D2732-058 rubber cushion 32894

29.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203

Magnabond B 104723

Instal support with magnabond 6398 per dwg D412-664-203,
cure for 12hrs before packaging.

Time & date of application: 300 07-07-19

BT 07-07-19

30.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/99 ①

31.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Wednesday, 1/24/2007 4:45:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30426

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

32.0 AN640A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M103177 ✓

33.0 AN641A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100743 ✓

34.0 AN960JD616 Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M103641 ✓

35.0 MS21042L6 Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M1016601 ✓

36.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

37.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

Time & date of packaging: 2:05 PM

Location: _____

PPP Rev: G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/07/26
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 30426

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

38.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

1/24/07

Job Completion



1/24/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30426
Description: Crosstube Assembly (412 High Aft)	Part Number:	D412-664-243
Inspection Dwg: D412-664-243 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

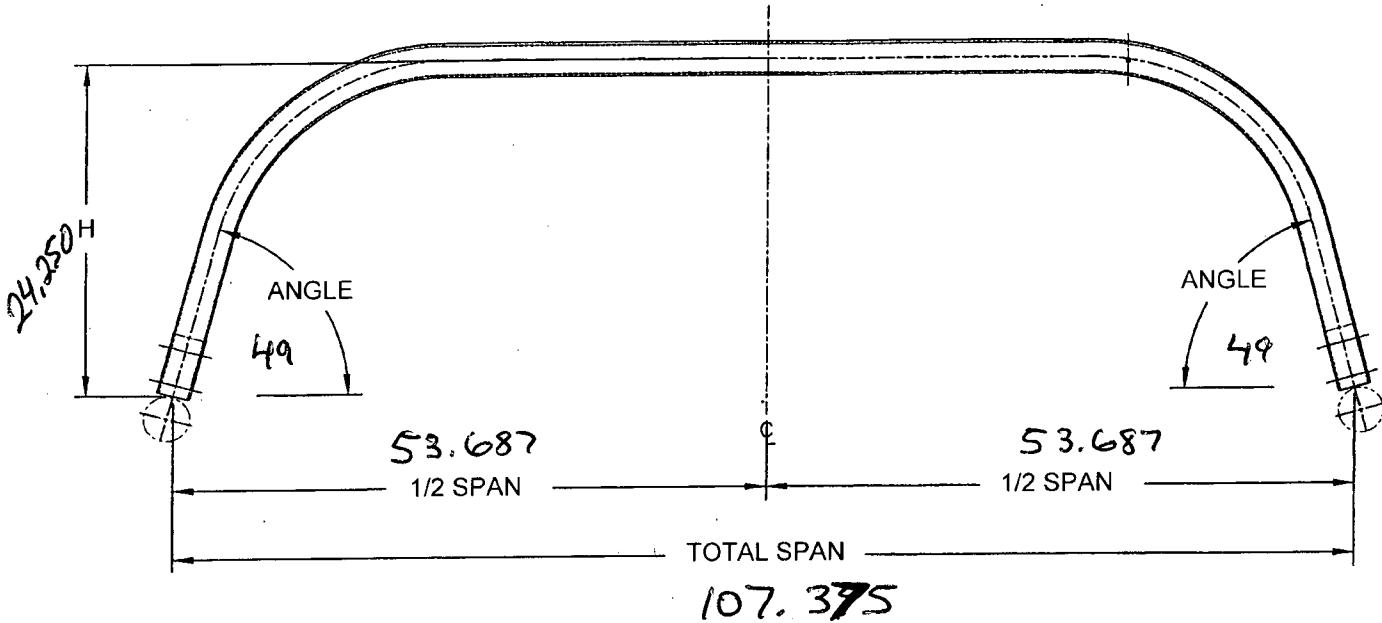
First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.689	—		
	2.748	+0.005/-0.000	2.753	—		
	2.884	+0.005/-0.000	2.889	—		
	3.019	+0.005/-0.000	3.024	—		
	3.163	+0.005/-0.000	3.166	—		
	3.308	+0.005/-0.000	3.311	—		
	3.429	+0.005/-0.000	3.432	—		
	2.990	+0.005/-0.000	2.991	—		
	2.618	+0.005/-0.000	2.621	—		
	0.200	+/-0.010	0.207	—		
	R0.063	+/-0.010	R0.063	—		
	R0.500	+/-0.010	R0.500	—		
	4.971	+/-0.001	4.971	—		
SIDE B	2.684	+0.005/-0.000	2.689	—		
	2.748	+0.005/-0.000	2.752	—		
	2.884	+0.005/-0.000	2.889	—		
	3.019	+0.005/-0.000	3.024	—		
	3.163	+0.005/-0.000	3.168	—		
	3.308	+0.005/-0.000	3.311	—		
	3.429	+0.005/-0.000	3.432	—		
	2.990	+0.005/-0.000	2.991	—		
	2.618	+0.005/-0.000	2.621	—		
	0.200	+/-0.010	0.206	—		
	R0.063	+/-0.010	R0.063	—		
	R0.500	+/-0.010	R0.500	—		
	4.971	+/-0.001	4.971	—		
	124.09	+/-0.020	124.100	—		

Measured by:	<i>mk</i>	Audited by:	<i>SA</i>	Prototype Approval:	N/A
Date:	07/02/03	Date:	07.02.03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM <i>JK</i>	<i>SA</i>

Crosstube Bend Dimension Sheet



PART NUMBER: 1412664203

BATCH NUMBER: 30426

DRAWING: 1412664243 REVISION: C

H: 24.37

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50°

QC 15: AA

DATE: 07/03/08

QTY: 10

Fit in table jig

DART

DESIGN <i>PH</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>AB</i>	DRAWING NO. D412-664-243	REV. C SHEET 1 OF 3
DATE 06.10.27		TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE NTS
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	

RELEASED

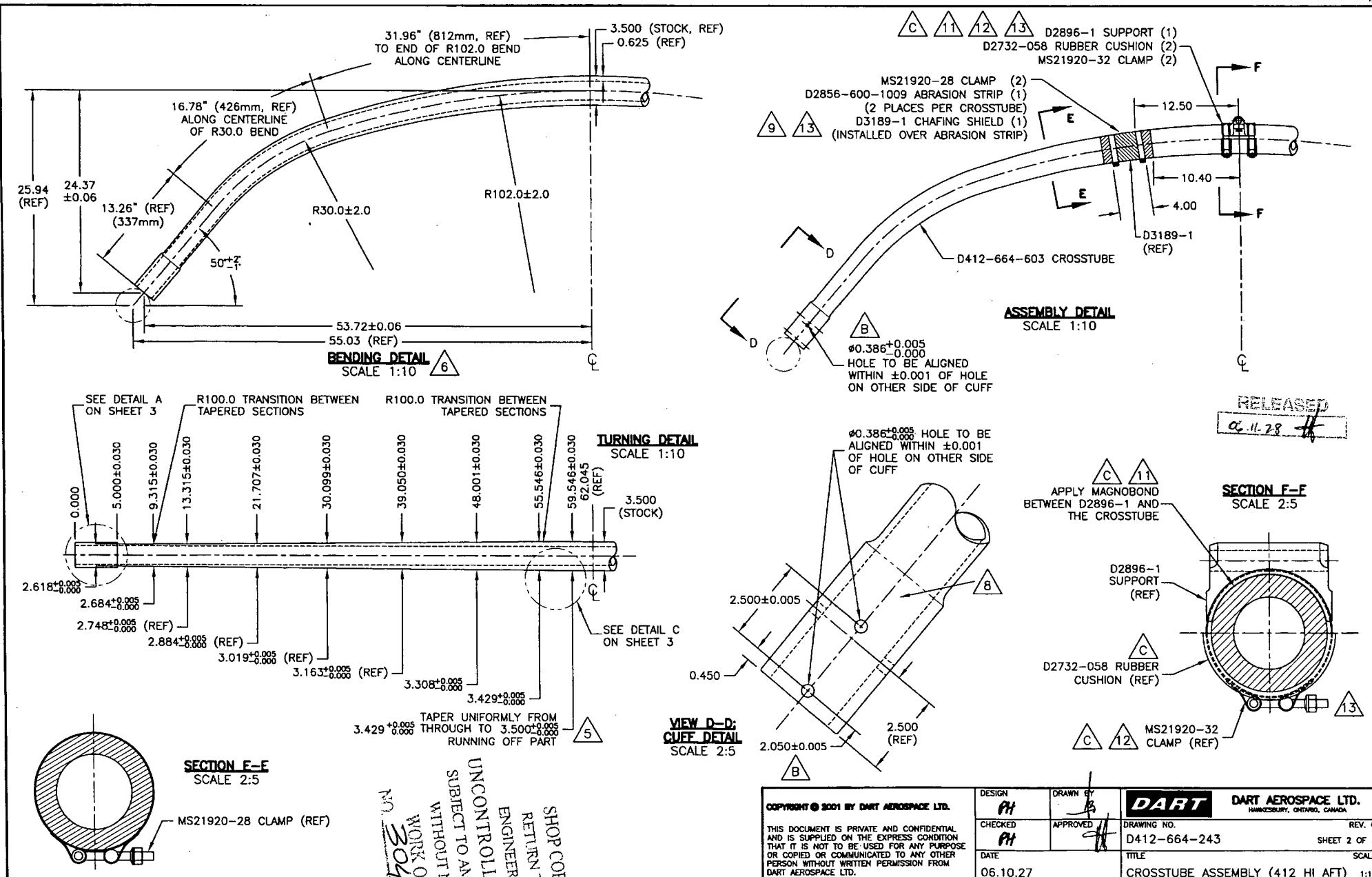
06.10.27 *AB***PARTS LIST:**

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D2732-058	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-32	CLAMP
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

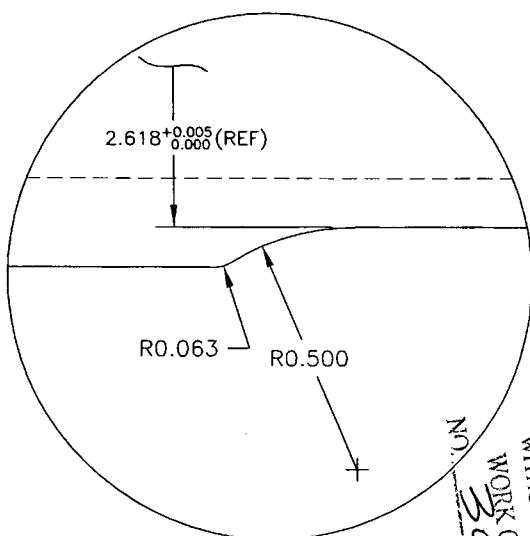
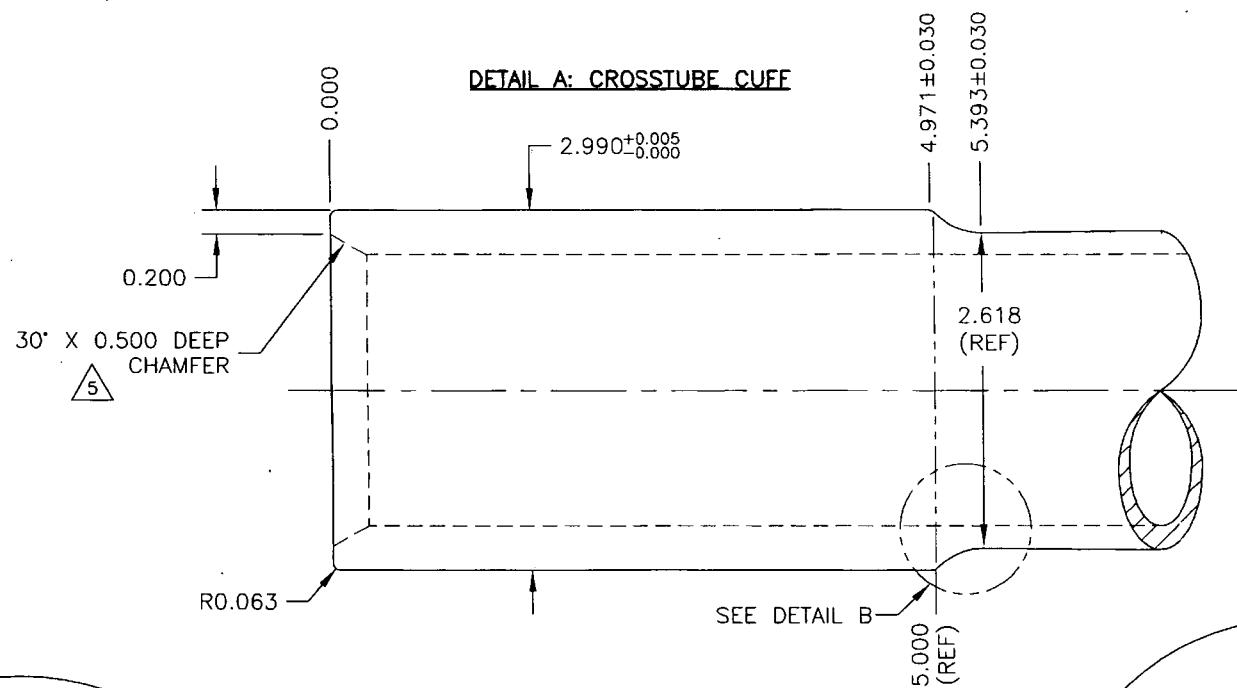
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR PACKAGING.
- 12) INSTALL MS21920-32 CLAMPS WITH D2732-058 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE
- 13) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30426*

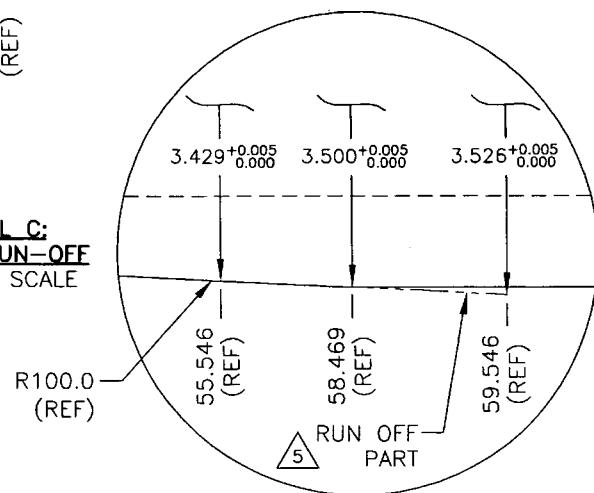


RELEASED
06.11.28



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WITHOUT NOTICE
WORK ORDER
NO. 3012

**DETAIL C:
TAPER RUN-OFF**
NOT TO SCALE



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DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
PH	PH	PH	REV. C
CHECKED	APPROVED	D412-664-243	SHEET 3 OF 3
DATE	SCALE	TITLE	CROSSTUBE ASSEMBLY (412 HI AFT) 1:1

06.10.27



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36071

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (2) P/N D206-667-203 S/N's B30435 and B30432.

Qty (2) P/N D412-664-245 S/N's B31436 and B31140.

Qty (2) P/N D412-664-203 S/N B30426 and B30424.

RADIOGRAPHY

ULTRASONIC

PENETRANT

MAGNETIC PARTICLE

EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(6) cross tubes inspected. (6) PASSED / (0) FAILED.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: *John Lacelle*

DATE: March 30, 2007

INSPECTION
STAMP(S)

CUSTOMER: Dart Aerospace

ADDRESS:

CUSTOMER INFORMATION

P.O. NUMBER

PO 00003449

CONTACT NAME:

Linda Lacelle

LABOUR	@	\$
MATERIALS	@	
TRAVEL EXPENSES	@	GST
HOTEL EXPENSES	@	PST

INVOICE NO.

TOTAL \$